

AS AP

77703

N900040100

Setup Start ***NS1***

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Draw Nbr	Revision Nbr
D4070	A

0.00

0.00

Memo

Cut as per dwg

Prog rev: 1
dwg rev: 1

16

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Memo

131-10-9

QC8- Inspect parts - second check

0.00

0.00

Memo

0.00 δ 11/21/19

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77703

December-19-11 8:19:20 AM

77703

Page 2

Item ID: D4070-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp
Start Date: 19/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 20/12/2011 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg Memo	0.00 0.00		SB 11/12/19		(16)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		11/12/19 S 4/12/19		16			
150 *150* Small Fab Small Fab	 Memo Assemble rubber cushion as per dwg	0.00 0.00		SB 11/12/20					

W/O:		WORK ORDER CHANGES					
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Work Order ID 77703

December-19-11 8:19:20 AM

77703

Page 3

Item ID: D4070-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 19/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 20/12/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

170		0.00							
170									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/12/2011
 11/12/2011
 11/12/2011

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-19-11 8:19:24 AM

Page 1

Work Order ID: 77703

77703

Parent Item: D4070-041

D4070-041

Parent Item Name: Clamp

Start Date: 19/12/2011

Required Date: 20/12/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A 10.02.16 new issue EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2182B

Manufactured

No

f

582.7642

1.263158

D2182B

**

Rubber Cushion

5/12/20

Location

Loc Qty

Loc Code

ST410

582.76417

66063

53.94817

73932

528.816

26

Cut qty 1 at 1.80" long

M304S16GA

Purchased

No

100

sf

181.8300

0.019

0.16

M304S16GA

**

304/316 Sheet .063

1560
B11-12-19

Location

Loc Qty

Loc Code

MAT020

181.83

119346

32

119653

149.83

119653

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77703
Description: Clamp		Part Number:	D4070-1
Inspection Dwg: D4070	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266	+0.006/-0.001	.268	✓	✗	✓ BGL	
0.375	+/-0.010	.376	✓		✓	
0.750	+/-0.010	.755	✓		✓	
0.375	+/-0.010	.379	✓		✓	
2.903	+/-0.010	2.902	✓		✓	
3.653	+/-0.010	3.650	✓		✓	
0.063	+/-0.010	.062	✓		✓	

Measured by: RB	Audited by: 8	Prototype Approval:	N/A
Date: 11-12-19	Date: 11/17/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.02.18	New Issue	KJ	AA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

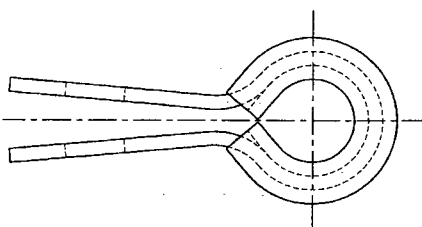
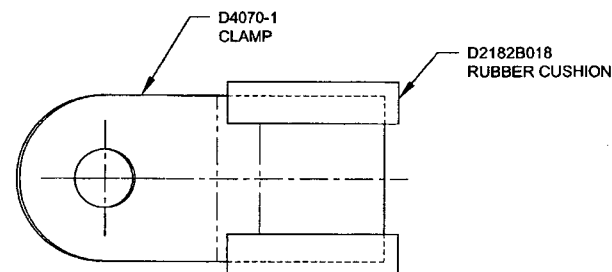
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

QTY	PART NUMBER	DESCRIPTION
X	D4070-041	CLAMP
1	D4070-1	CLAMP
1	D2182B018	RUBBER CUSHION



D4070-041 CLAMP

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

77703 H.L.J.
11/12/19

RELEASED
2010-02-16
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4070-041" USING REMOVABLE TAG
- 7) WEIGHT: 0.05 lbs

A	NEW ISSUE	CP	10.02.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4070
TITLE CLAMP
REV. A
SHEET 1 OF 3
SCALE NTS

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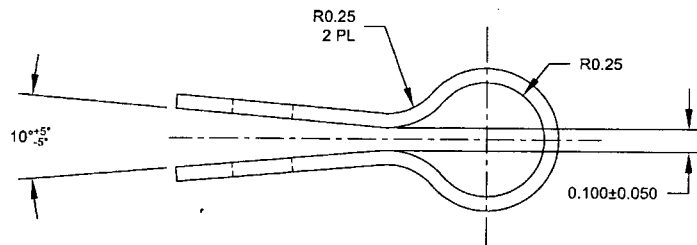
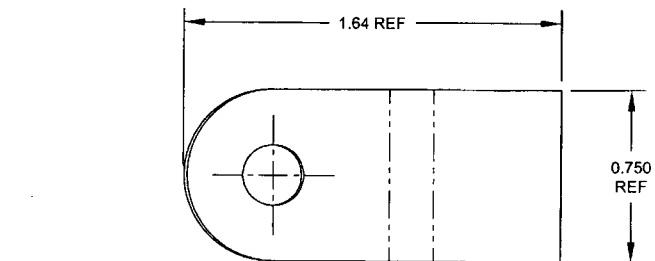
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

77703



D4070-1 CLAMP
(MAKE FROM D4070-1F)

RELEASED
2010-02-16

NOTES:

- 1) MATERIAL: MAKE FROM D4070-1F
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D4070	SHEET 2 OF 3
APPROVED	97	TITLE	SCALE
DE APPR.	97	CLAMP	NTS
DATE	10.02.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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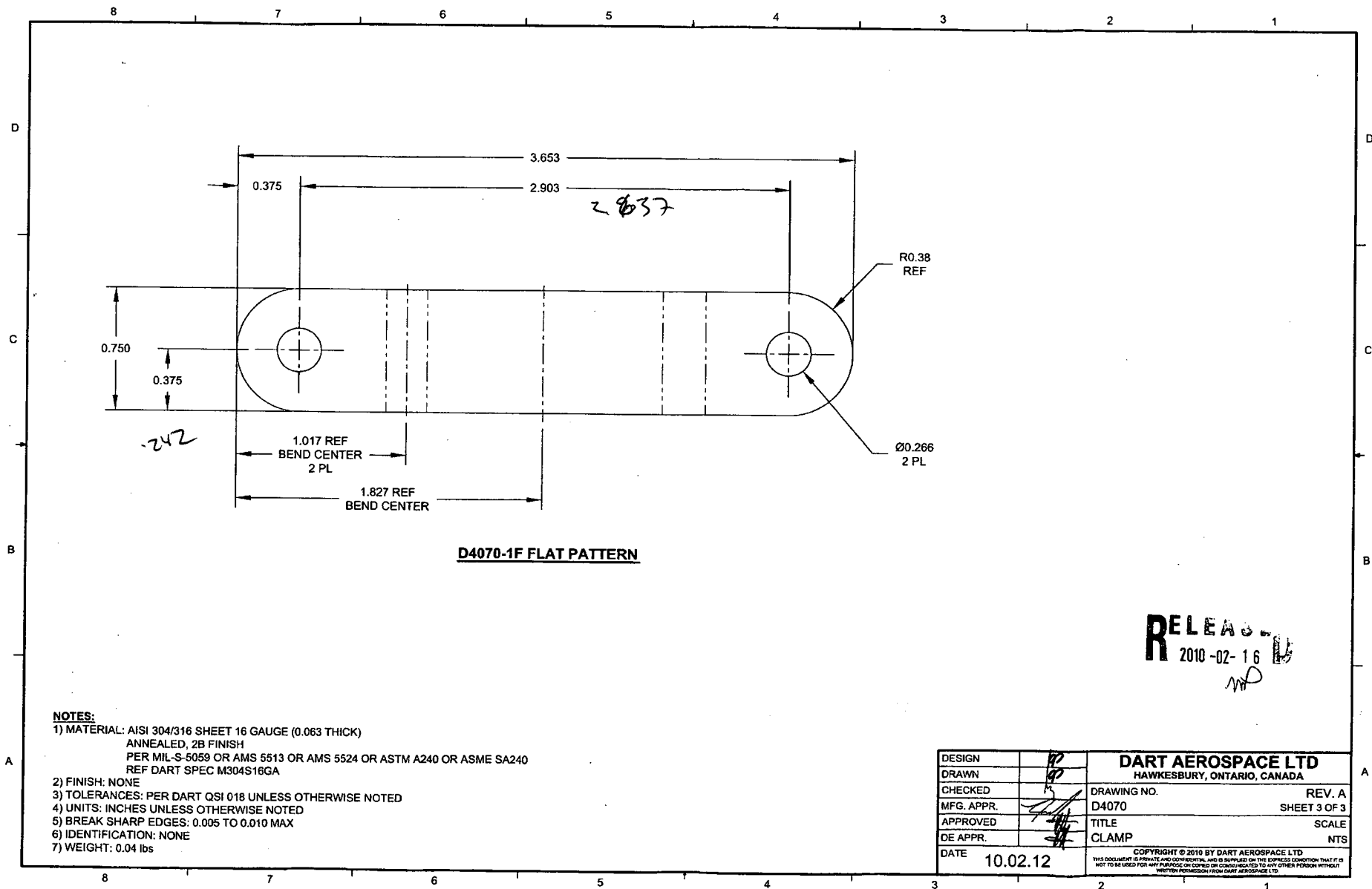
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